

Date: Wednesday, 3/21/2007 1:59:10 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARPAD
Job Number	31401		
Estimate Number	12801		
P.O. Number	N/A	Part Number	D35377
This Issue	3/21/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3537 REV A
First Issue	N/A	Project Number	N/A
Previous Run	31165	Drawing Revision	A
Written By		Material	N/A
Checked & Approved By	<u>KJ</u> 07.03.21	Due Date	3/30/2007
Comment	Est.Rev.A New Issue 07-03-12 ec	Qty:	10
Um:	Each		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S16GA	304/316 .063 Sheet	
		Comment: Qty.: 0.1512 sf(s)/Unit Total : 1.5120 sf(s) M304S16GA Stainless steel sheet .063" thick Batch: M101873	SAD 07/03/24
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: A Prog Rev: A	SAD 07/03/24 (10)
		2-Deburr if necessary	(10)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	SAD 07/03/24 (10)
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	On 07/03/25 K10
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326.	 07/03/27 (10)
			SAD 07/03/28 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: WEARPAD

Job Number: 31401

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



07/03/28 (10)

(PTD)

Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429 - N/A

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty	Description	Batch
A/R	2059B Hardcoat	MAR755
Weld hardcoat as per Dwg D3437		

FC 07/04/03 (10)

8.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/04/03 (10)

9.0 QC5

INSPECT WORK TO CURRENT STEP



07/04/03 (10)

Comment: INSPECT WORK TO CURRENT STEP

10.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FL 07/04/04 (10)

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/04/04 (10)

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/04/04 (10)

13.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/04 (10)

Job Completion



07/04/04

Dart Aerospace Ltd

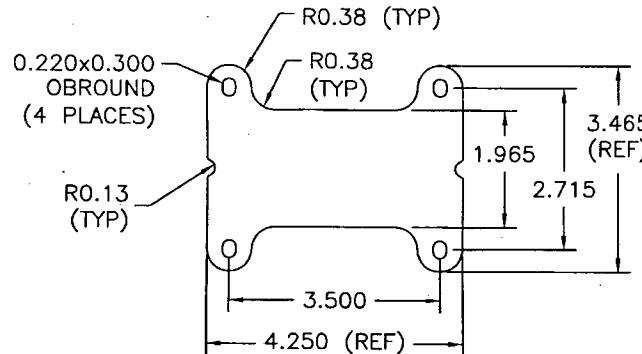
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
0703-28	60	Remove Toggle. Rem. change.				0703-28	0703-28

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/04/04
 QA: N/C Closed: _____ Date: _____

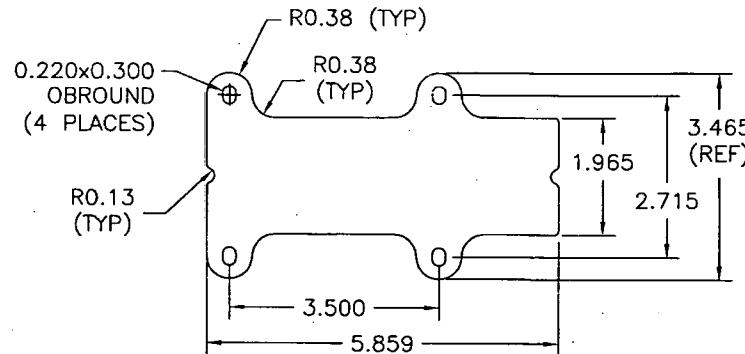
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

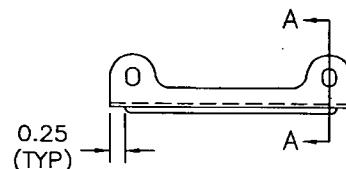
D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN



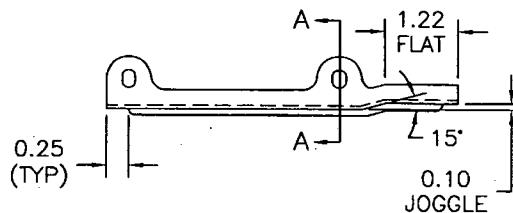
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



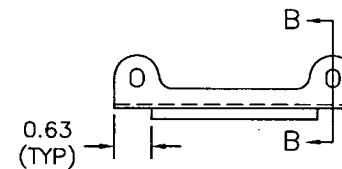
RELEASED

07.02.12

D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)



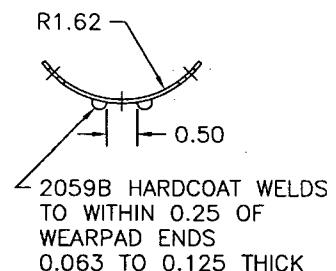
NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE (0.063 THICK, REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

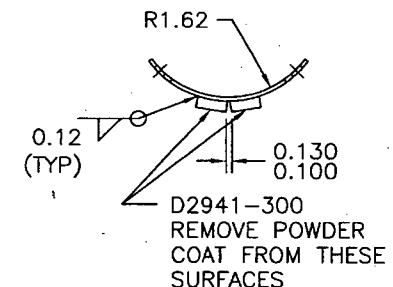
WORK ORDER NO. 31401
4.3
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ENGINEERING
RETURN TO
SHOP COPY

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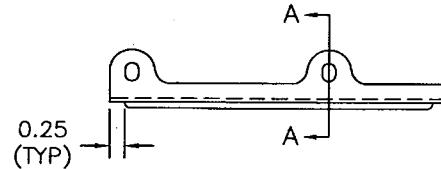
SECTION A-A



SECTION B-B



D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)



A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	
CB	CB	DART DART AEROSPACE USA, INC. PORT HUOLOCK, VA
CHECKED	APPROVED	REV. A
PH	PH	DRAWING NO. D3537
DATE	TITLE	SHEET 1 OF 1 WEARPAD
06.11.06		SCALE 1:2

DART AEROSPACE LTD

Work Order: 31461

Description: WearPad

Part Number: D35377

Inspection Dwg: D3537 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 5.859	+/- 0.010	5.860	✓		Vern	
B 3.465	+/- 0.010	3.460	✓		Vern	
C 2.715	+/- 0.010	2.710	✓		Vern	
D 1.965	+/- 0.010	1.971	✓		Vern	
E 0.220	+/- 0.010	0.222	✓		Vern	
F 0.360	+/- 0.010	0.366	✓		Vern	
G 0.063	+/- 0.010	0.055	/		Vern	
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	SAM
Date:	07/03/24

Audited by:	CH
Date:	07/03/24

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	

